

S212388



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6103-003

Job Sheet 199765



Part No: D6103-003

Job Qty: 20 pcs

Part Name: Round Billet, Aluminum



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/30/19

Job Tracking No:

Created By: Chantal Lavoie

Due Date: 9/23/19

Description:

Type: Stock

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
100	Purchasing	20 pcs	9/23/19	0.00	0.00		Purchasing - 1	
	AUG 30 2019						Purchasing - 2	At 19/09/10
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	20 pcs	9/23/19	0.00	0.00		Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	At 19/09/10



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S212388



Part: D6103-003

Job No: 199765

Serial No/Batch: S212388

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/10/19

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 18 - 12	
				QC 18 - 14	
120 QC 18	20 pcs	9/23/19	0.00 0.00	QC 18 - 22	
				QC 18 - 25	
				QC 18 - 48	
				QC 18 - 58	
				QC 18 - 61	DAS
				QC 18 - 9	61
				QC 18 - 81	9-89
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
130 Packaging 3-1 - Stock - B4B	20 pcs	9/23/19	0.00 0.00	Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	20 pcs	9/23/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 100 - (Purchasing) Issue P/O: _____ a)Description: Alluminum round billet b) Ø3.500" x 12.500" long c) Descriptions: Tolerance on all dimensions are +0.030"/-0.000" d) Material: 7075-T7351 (QQ-A-225/9) Material certification required 110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material certification is attached					

8/30/2019

[Dart Hawkesbury] Job Sheet - Lavoie, Chantal

120 - QC18 (QC18 In-Coming Inspection Material)

130 - (Identify as per dwg & Stock Location: _____) LOCATION: MAT043

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003P	Round Alum Billet	20 pcs (1 ea)	100-Purchasing	5212381

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6103-003P	20	0	0

Part Specifications

Specifications could not be found.

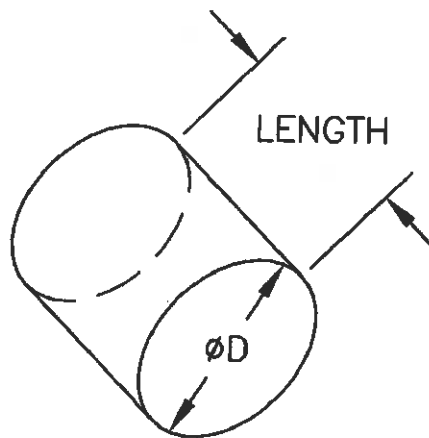
Plex 8/30/19 8:07 AM Dart.Lavoie.Chantal



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07 [Signature]



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044388**



Supplier: MEC002-VU
Metaux Castie
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044388

PO Date: 8/30/19

Due Date: 9/23/19

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavole, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
AUG 30 2019

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		M7075T6S0.375X6.000		7075-T6S Sheet .375" Thick Plate X 6" Wide : MATERIAL: 7075- T6/T62/T651 ALUMINUM SHEET OR PLATE SPECIFICATION: QQ-A-250/12 OR AMS-QQ-A- 250/12 OR AMS 4045 OR ASTM B209 OR MATERIAL: 7075- T6/T62/T65/ ALCLAD ALUMINUM SHEET OR PLATE SPECIFICATION: QQ-A-250/13 OR AMS-QQ-A- 250/13 OR AMS 4048 / 4049 OR ASTM B209 receive ft	Firmed	-	10/17/19	12 ft	0 ft	12 ft	\$36.21/ft	\$434.52



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044388



Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
2		M7075T6S2.000X7.000		7075-T6S Sheet 2" Thick Plate X 7" Wide (Order In Billets - 13.375") : MATERIAL: 7075-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/12 OR AMS-QQ-A- 250/12 OR AMS 4045 OR ASTM B209 receive ft	Firmed	-	9/23/19	56 ft	0 ft	56 ft	\$76.785714/ft	\$4,300.00
Line Item Note 50 PCS CUT @ 13.375" = 56 FT												
3		M7075T6S1.000X5.000		7075-T6 Sheet 1" Thick Plate X 5" Wide : MATERIAL: 7075-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/12 OR AMS-QQ-A- 250/12 OR AMS 4045 OR ASTM B209 receive ft	Firmed	-	9/23/19	24 ft	0 ft	24 ft	\$36.10/ft	\$866.40
4	199765	D6103-003P		Round Alum Billet AS PER DWG D6103 REV. B MATERIAL: 7075-T7351 AS PER QQ-A-225/9 SIZE: 3.500" X 12.500" LONG	Firmed	-	9/23/19	20 pcs / 22x	0 pcs	20 pcs AT 19/09/10	\$60.40/pcs	\$1,208.00
Grand Total:											\$6,808.92	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/30/19 11:11 AM Dart.Lavoie.Chantal



Castle Metals®

A. M. Castle & Co.

**PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

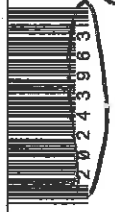
Page 1 of 1

Shipment No:3985145

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN	Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA
Date Shipped 04-SEP-19	F.O.B. ORIGIN	Freight Terms Prepaid	Carrier LOCAL_FLEET	BOL No 3985145-6

Shipment Details

Final Destination Branch - TOR

Order No 5583682	Line No 1	Item No 8808.MO	Description 3.5000..RD.7075.T7351.ALUMINUM.CF.144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS-QQ-A-225/9	
Purchase Order No POHB044388	Part Number YOUR ITEM NUMBER: D6103-003	Ordered Qty 22.00 PCS		Invoice Qty 22.00 PCS
		Details ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS		
Delivery No. 122867538	Mill/Source KAISER ALUMINUM	Heat Number 	Mech Id 22	Width (IN)
				Length (IN)
				Shipped Qty(LBS) 266.7582

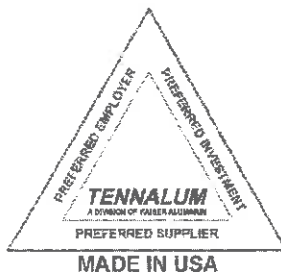
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cannot be returned for credit.			
Reviewed by Authorized Castle Metals Representative:	SEP 04 2019	Date:	Name: 

Date Printed: 04-SEP-2019 03:44:17 PM



KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
309 Industrial Drive
Jackson, TN 38301
731-423-2811



CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

CUSTOMER PO NUMBER: 507773-1		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 730762	LINE ITEM: 1	SHIP DATE: 05/28/2019	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 2244 lbs.	QUANTITY: 16 pcs.	B/L NUMBER: 43785	DIA/DIAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co 3800 Enterprise Drive Janesville, WI 53546 USA			SOLD TO: A M Castle & Co 1420 Kensington Road Suite 220 Oak Brook, IL 60523 USA		

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20243963	71.0	59.9	15.0	39.2

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Zr	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.08	0.25	1.3	0.04	2.7	0.19	5.7	0.03	0.01			20243963
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	0.15	
Min			1.2		2.1	0.18	5.1					

Specifications

Standard: ISO 9001, **ASTMB211-19**, AMS4124F, **AMS-QQ-A-225/9A** Non-Standard: A97075_11_R17

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 265861

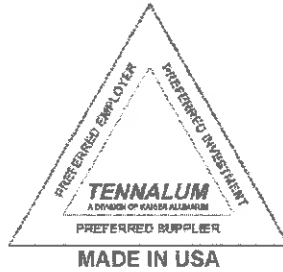
Kaiser Order Number: 730762

Line Item: 1

KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
309 Industrial Drive
Jackson, TN 38301
731-423-2811



CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. AS9100D:2016 The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES. Material complies with FAR BAA (FAR 52.225-1, Buy American Act-Supplies), DFARS BAA (DFARS 252.225-7001 Buy American Act & Bal of Payments Prog), and FAR TAA (FAR 52.225-5 Trade Agreements). No weld repair. This material is compliant to RoHS 3, European Union Directive 2011/65/EU and 2015/863/EU.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 265861

Kaiser Order Number: 730762

Line Item: 1

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6103-003
 DATE: 19/09/10

PO / BATCH NO.: PO4B044388/521238

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 22x
 QUANTITY INSPECTED: 22x
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 3.500"
 THICKNESS RECEIVED: 3.500"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	AMS-20-A-225/9
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HEAT TREATING L# 202429/3
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 61 9-89</u> DATE: <u>SEP 10 2019</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in